

D 206-642-611

Date: Friday, 1/25/2008 10:41:16 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT SKIDTUBE LH 206A/B  
 Job Number : 36956  
 Estimate Number : 10801  
 P.O. Number :  
 This Issue : 1/25/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D206642611  
 First Issue : 1 / Type : LANDING GEAR Drawing Number : N/A  
 Previous Run : 36955 Drawing Revision : L  
 Material :  
 Due Date : 3/10/2008 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev:B 05.10.27 Revised pick list KJ/EC  
 Est Rev:C 07-12-05 ECN 1080p Rev:L DD verified by:

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-611 CHG003

AS 08/04/23 8/4/23 JLD

2.0 36956A FLOAT SKIDTUBE HIGH GEAR 206 A/B



Comment: Sub-Component FLOAT SKIDTUBE HIGH GEAR 206 A/B

D206-642-641 B 36956A

AS 08/04/22 (X)

3.0 D206651041 206 A/B GHW Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

1 D206-651-041 GHW Kit Batch: 347F3

AS

4.0 D2652 Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 D2652 Bushing 3985

AS 08/04/22 (X)

5.0 D26651 Saddle, LH Fwd Aft Out



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2665-1 Saddle 35803

AS 08/04/22 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: FLOAT SKIDTUBE LH 206A/B

Job Number: 36956

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D26661

Saddle, LH, Fwd,Aft, In



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2666-1 Saddle

34628 31859

AS

08/04/22 (X)

7.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

10 D2712 Set Screw

34628

AS

08/04/22 (X)

8.0

D2884

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2884 Saddle Spacer

B35497

AS

08/04/22 (X)

9.0

D2885

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2885 Saddle Spacer

B37342

AS

08/04/22 (X)

10.0

D33963

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3396-3 Spacer

M36336

AS

08/04/22 (X)

11.0

AN3C36A

BOLT



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

6 AN3C36A Bolt

M106541

AS

08/04/22 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE LH 206AB

Job Number: 36956

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

MS21250 03004

HIGH STEEL BOLT



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

HIGH STEEL BOLT

batch M106277

AS

08/04/22 (X)

13.0

D36721

PHENOLIC WASHER



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

PHENOLIC WASHER

batch B34470

AS

08/04/22 (X)

14.0

AN4C6A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 AN4C6A Bolt M106519

AS

08/04/22 (X)

15.0

AN5C7A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batc

4 AN5C7A Bolt M19185

AS

08/04/22 (X)

16.0

AN5C11A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN5C11A Bolt M107013

AS

08/04/22 (X)

17.0

AN5C32A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN5C32A Bolt M105746

AS

08/04/22 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE LH 206AVB

Job Number: 36956

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN5C35A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batc

1 AN5C35A Bolt M107551

AS 08/04/22 (XU)

19.0

AN5C13A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

bolt

batch M107615

AS 08/04/22 (XU)

20.0

AN6C44A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batc

2 AN6C44A Bolt M107314

AS 08/04/22 (XU)

21.0

AN3C41A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

batch M107463

AS 08/04/22 (XU)

22.0

AN960C10L

washer



Comment: Qty.: 30.0000 Each(s)/Unit Total : 30.0000 Each(s)

Pick:

Qty Part Number Description Batch

30 AN960C10L Washer M107321

AS 08/04/22 (XU)

23.0

AN960C416L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

24 AN960C416L Washer M107008

AS 08/04/22 (XU)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE LH 206AB

Job Number: 36956

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN960C516L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 AN960C516L Washer M103344

AS 08/04/22 (X)

25.0

AN960C616

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN960C616 Bolt M19185

AS 08/04/22 (X)

26.0

MS210433

Nut



Comment: Qty.: 17.0000 Each(s)/Unit Total : 17.0000 Each(s)

Pick:

Qty Part Number Description Batch

17 MS21043-3Nut M107288

AS 08/04/22 (X)

27.0

MS210434

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 MS21043-4Nut M107101

AS 08/04/22 (X)

28.0

MS210435

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS21043-5Nut M106763

AS 08/04/22 (X)

29.0

MS210436

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

M107376

AS 08/04/22 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE LH 206A/B

Job Number: 36956

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 ms21043-6 Nut

30.0

AN960JD10

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

batch

M107715

AS 08/04/22 (X)

31.0

D36831

INSERT



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

INSERT

batch

36319

AS 08/04/22 (X)

32.0

D36727

PHENOLIC WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PHENOLIC WASHER

batch

~~B36727~~ B35522

AS 08/04/22 (X)

33.0

D36725

PHENOLIC WASHER



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

PHENOLIC WASHER

batch

B35521

AS 08/04/22 (X)

34.0

D36723

PHENOLIC WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

PHENOLIC WASHER

batch

B34471

\* Batch in Not comp

52 remaining in Box

AS 08/04/22 (X)

35.0

MS27039C105

SCREW



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

SCREW

batch

M106574

AS 08/04/22 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE LH 206AB

Job Number: 36956

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/01/23 (K)

37.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-611

Location: PPD 36956A

PPP Rev: Rev C

08/04/23 (K)

38.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/24 (K)

Job Completion



08/04/23

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 1/25/2008 10:41:52 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT SKIDTUBE HIGH GEAR 206 A/B  
 Job Number : 36956A  
 Estimate Number : 10803  
 P.O. Number :  
 This Issue : 1/25/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D206642641  
 First Issue : 1/1 Type : LANDING GEAR Drawing Number : D3288 REV F U/R  
 Previous Run : 36955A Drawing Revision : F  
 Material :  
 Due Date : 3/10/2008 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev:B 05.11.15 Added washers for aft cap, wearshoes and ring EC  
 Est Rev:C 06-05-31 Revised steps JLM  
 Est Rev:D 07-02-22 Added SS Wearplates & Gaskets JLM  
 Est Rev:E 07-12-06 ECN 1080p DD verified by:

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-641 CHG003

N/A

2.0 D2620 Bent 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2620 3" OD Bent Tube B 34693

①

N

8-3-26

3.0 D2647 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2647 Fwd Cap

B 35475

BE

8-3-26

4.0 D32861 Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-1 Doubler

B 33895

②

N

8-3-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 36956A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr FWD edge of tube,grind bending marks.

2-Remove ridge on inside of fwd edge of tube as per Dwg D3288.

3-Weld Fwd Cap as per Dwg D3288,Grind to obtain proper fit

A/R AL ROD

Batch: *m106330 / m106762 RE 08-03-26*

4-Grind welds flush to cap on top surface only.

5-Cut Aft end as per Dwg D3288 from front of tube then deburr

6-Remove inner indexing ridge on aft end as per Dwg d3288

7-Open holes for aft cap as per Dwg D3288 using Dt8025

8-Drill pilot holes using DT8818

9-Insert D3286-1 doubler using DT8732 & DT8879 ,then locating doubler off the  
D3286-1 doubler ,leave Dt8732 for added support

3/16" holes cleco

10-Drill D3286-1 doubler rivet holes in tube using #40 drill,spot drilling doubler at the same time.

11-Working from center out,drill #30 holes into D3286-1 Doubler.cleco each hole after its drilled,Verify  
angle of holes to accomodate rivet heads.

12-Remove 3/16" clecos only and open GHW holes to .500" as per Dwg D3288.

13-Remove D3286-1 doubler,identify orientation,deburr then attach to W/O

14-Remove indexing edge as per Dwg D3288.

15-C'sink rivet holes as per Dwg D3288.

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*6 08/03/31 (FD)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 36956A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

K 8-4-1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/04/01

9.0

CR3212404

Cherry Rivet



Comment: Qty.: 52.0000 Each(s)/Unit Total : 52.0000 Each(s)

Pick:

Qty Part Number Description Batch

52 CR3212-4-04 Rivet

M 107008

52

8-4-1 K

10.0

D3289041

Float Web (206A/B)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3289-041 Float Web

36187

SL 8-4-1

11.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Holes to finished size as per DWg D3288.Deburr.

2-Locate, install and rivet doublers as per Dwg D3288. Micro-shave rivets as required.

3-Bond web in place as per Dwg D3288 & QSI 015.

A/R Sikaflex-291

105585

Sikaflex expire date:

8-7-31

Start: 8-4-1

Time: 4:10

Finish: 08/04/01

Time: 7:30AM

(Adhere for 12 hours)

SL 8-4-1

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/02 (L)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

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Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 36956A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube using program D3288 as per Dwg D3288. Install drop pins in cross bolt spacer holes to maintain web position.

EL 8-4-2

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes for wearplates using D3288-T2 as per Dwg D3288, then open to Ø0.297". (without cutting fluid)

DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)

2-C'sink X-bolt holes.

3-Debur

8-4-5

15.0

D2649

Crossbolt Spacer



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Pick:

Qty Part Number Description Batch

9 D2649 Crossbolt spacer

B 37329

BE 08/04/07

16.0

D32751

Crossbolt Spacer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

6 D3275-1 Crossbolt spacer

B 34619

BE 08/04/07

17.0

D32863

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-3

Spacer

B 35048

BE 08/04/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 1/25/2008 10:41:52 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A

Job Number: 36956A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description:

18.0

LANDING GEAR.1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3288. Remember to back drill each hole before welding the other side. Use aluminum rod.

A/R Aluminum Rod *M106330 BE 08/04/07*

2-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3288. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required

A/RSS Rod *NONE BE 08/04/07*

3-Grind welds flush to Fwd cap on top surface only.

4-Grind cross bolt welds flush as per Dwg D3288. Masking Tape access to inside of the skidtube

5-Counterbore 5/16" x 0.750" deep using DT8747, except 8th cross bolt hole from Aft end, as per Dwg D3288.

*H 8-4-9*  
*H 8-4-10*

19.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*PD 08-04-10 (1)*

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*5 08/04/10 (2)*

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

*911 08-04-14 (x1)*

22.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*BL 08-04-15 (1) (P10)*

23.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*M-L 08/04/21 (1X)*

*30 min.*  
*17/04/2008*  
*S.045*  
*#1*  
*13.58*  
*330.8*  
*#336956-A*  
*#D206642641*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206642-641 PAR #: N/A Fault Category: Prod/Finishing NCR: (Yes) No DQA: D Date: 08/04/24  
 QA: N/C Closed: D Date: 08/04/24

NCR: <u>36956A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/04/16	2.0	There was a bare marking on the top of the shock tube, behind the aft saddle location. L.C: Appears that while the tube was being powder coated the employee hit or rubbed the tube by accident with the gun.	<u>[Signature]</u> 08/04/16	Scuff entire tube with a 320 grit. and clean. Re-powder coat as per OSI COS. Ensure to inspect coverage and parts prior to putting them in the oven.	<u>[Signature]</u> 08-04-16 08/04/17	<u>[Signature]</u> 08/04/24	<u>[Signature]</u> 08/04/24	<u>[Signature]</u> 08/04/16

NOTE: Date & initial all entries



Date: Friday, 1/25/2008 10:41:52 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 36956A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

D3415041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3415-041 Nut Plate

B33842

M-h

25.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivet

M106825

M-h

\*

26.0

CR3212403

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CR3212-4-03 Rivet

M15918

M-h

27.0

ALS71032130

Insert



Comment: Qty.: 64.0000 Each(s)/Unit Total : 64.0000 Each(s)

Insert

Batch:

M105855

M-h

28.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(ix)

Comment: HAND FINISHING RESOURCE #1

1-Install D3415-041 Nut Plate as per Dwg D3288 ,Install with LPS-3

A/R LPS-3 Batch:

M105005

2-Install inserts Dwg D3288. Use a drop of Sikaflex inside insert holes

A/R Sikaflex-291

Sikaflex expire date:

M107397  
08/10

M-h 08/04/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 1/25/2008 10:41:52 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 36956A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP  
Inserts & Nut plate

08/04/21 (90)

30.0

D353515

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
WEARSHOE  
Batch: B 36653

m-h

31.0

D353521

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
WEARSHOE  
Batch: B 31991

m-h

32.0

D353535

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
WEARSHOE  
Batch: B 36425

m-h

33.0

D353541

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
WEARSHOE  
Batch: B 31993

m-h

34.0

D353615

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
GASKET  
Batch: B 33964

m-h

35.0

D353621

GASKET



(X)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
GASKET

B 31995

m-h 08/04/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 1/25/2008 10:41:52 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 36956A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

D353635

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch:

B 38 183

m-h

37.0

D353641

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch:

B 31 997

m-h

38.0

D35371

WEARPAD



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

WEARPAD

Batch:

B 37 292

m-h

39.0

D35373

WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPAD

Batch:

B 33 881

m-h

40.0

AN3C4A

BOLT



Comment: Qty.: 66.0000 Each(s)/Unit Total : 66.0000 Each(s)

BOLT

Batch:

M 107 376

m-h

41.0

NAS1515H3L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch

M 106 516

m-h

42.0

AN960C10L

washer



Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Pick:

Qty Part Number Description Batch

78 AN960C10L Washer

M 107 376

m-h 08/04/21

(1X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 1/25/2008 10:41:52 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 36956A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

43.0

D36831

INSERT



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

INSERT

batch:

B36319

*m-h*

44.0

D34131

Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3413-1 Ring

B33949

*m-h*

45.0

AN4C5A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN4C5A Bolt

M104936

*m-h*

46.0

AN960C416

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

washer

batch:

M100993

*m-h*

47.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap

B37755

*m-h*

48.0

MS27039C105

SCREW



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

SCREW

batch:

M107008

\*

(IX)

*m-h*

08/04/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Friday, 1/25/2008 10:41:52 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 36956A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

49.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(IX)

Comment: HAND FINISHING RESOURCE #1

2-Install wearshoes/wearpads & Gaskets as per Dwg D3288.

3-Install Ring on Nut Plate as per detail F & Dwg D3288.

4-Spray inside tube with LPS-3 on both sides of web

5-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R Sikaflex-291

Sikaflex expire date:

M107397  
08/10

6-Coat all exposed fastners with LPS Procyon, remove any excess on powder coat with MEK Degreasser.

A/R LPS Procyon Batch:

M104251

M-h 08/04/21

50.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6 08/04/21 (C)

51.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-641

Location:

PPP Rev:

PPP-30956

SS 08/04/23 (X)

52.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/24

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



h 08/04/24

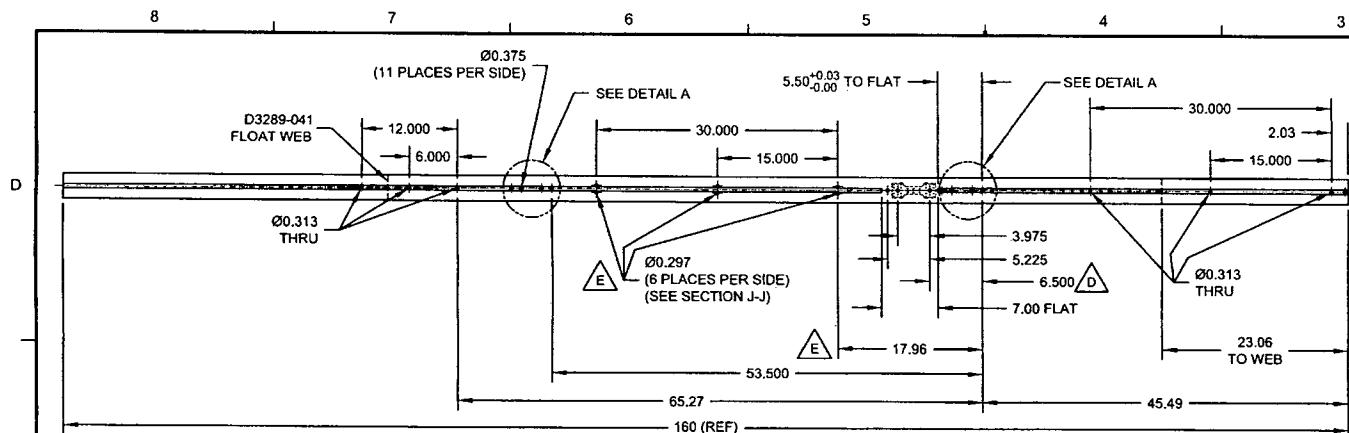
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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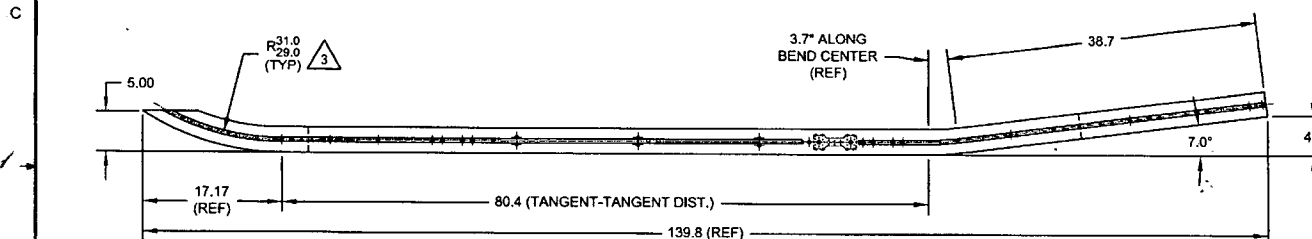
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

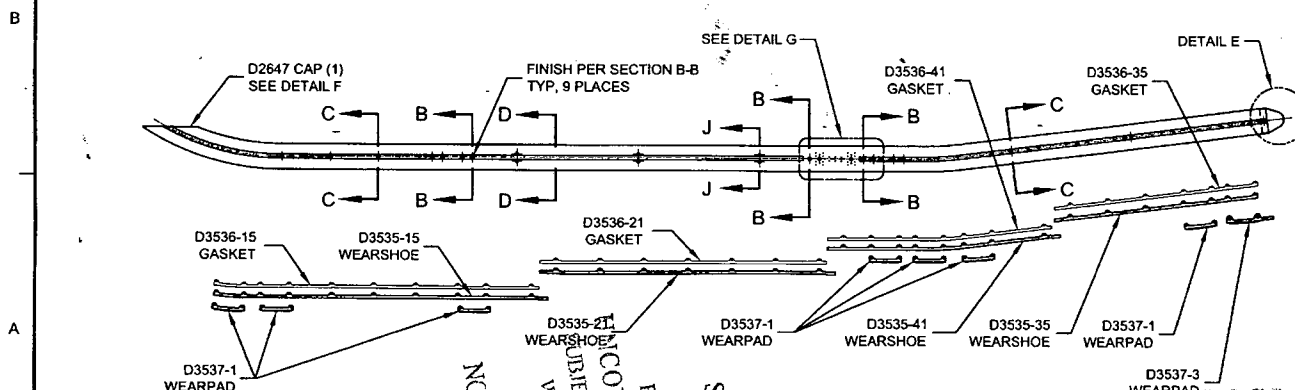
NOTE: Date & initial all entries



**D3288-041 DRILLING/WEB ASSEMBLY DETAIL**



**D3288-041 BENDING DETAIL**



**D3288-041 WELDING DETAIL/SKIDTUBE ASSEMBLY**

Qty	Part Number	Description
X	D3288-041	SKIDTUBE ASSEMBLY
1	D2600-1-240	EXTRUSION
1	D2646	AFT CAP
1	D2647	CAP
9	D2649	CROSS BOLT SPACER
6	D3275-1	CROSS BOLT SPACER
2	D3286-1	DOUBLER
2	D3286-3	SPACER
1	D3289-041	FLOAT WEB
1	D3413-1	RING
1	D3415-041	NUT PLATE
1	D3535-15	WEARSHOE
1	D3535-21	WEARSHOE
1	D3535-35	WEARSHOE
1	D3535-41	WEARSHOE
1	D3536-15	GASKET
1	D3536-21	GASKET
1	D3536-35	GASKET
1	D3536-41	GASKET
7	D3537-1	WEARPAD
1	D3537-3	WEARPAD
12	D3683-1	INSERT
64	ALST-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
66	AN302A	BOLT
1	AN4CSA	BOLT
1	AN960CA18	WASHER
78	AN960C10L	WASHER
2	CCR264SS3-3	RIVET
2	CR3212-4-03	RIVET
52	CR3212-4-04	RIVET
12	MS27039C1-05	SCREW (or AN3C3A BOLT)
2	NAS1515H3L	WASHER

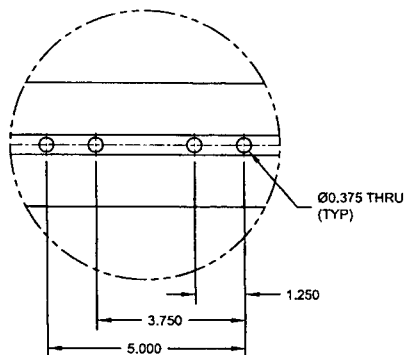
**GENERAL NOTES:**

1. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1  
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
2. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
3. DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
4. BOND D3289-041 FLOAT WEB INTO D3288-1 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. ALL HOLES DRILLED ON CENTERLINES.
6. DRILL Ø0.297 HOLES FOR D3683-1 INSERTS BEFORE FINISH. INSTALL D3683-1 INSERTS AFTER FINISH.
7. DRILL Ø0.297 HOLES FOR ALST-1032-130 INSERTS USING DT3288-1T2 BEFORE FINISH. INSTALL ALST-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX-241/291.
8. TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
9. UNITS: INCHES UNLESS OTHERWISE NOTED.
10. WELDING: PER DART QSI 004.

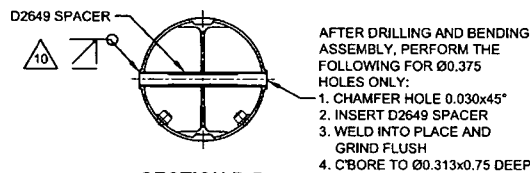
F	SUBSTITUTE FLOAT BAG INSERT W/SPEC CTRL DWG WAS ALST7-1032-130; IS NOW D3683-1	DC	07.11.21
E	MID-FLOAT HOLES WERE MOVED 2.00" FWD AND ROTATED INBOARD AND OUTBOARD BY 17" INSERTS ARE NOW INSTALLED AT THESE LOCATIONS	MB	07.09.14
D	DIMENSIONS ADDED	DC	07.06.04
C	NEW INSERTS. SS WEARSHOES AND GASKETS	PH	06.12.19
B	CHANGE INSERTS	CP	05.03.18
A	NEW ISSUE	CP	04.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	90		
DRAWN	DL		
CHECKED	PL		
MFG. APPR.	RE		
APPROVED	UP		
DE APPR.			
DATE	07.11.21		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3288 TITLE SKIDTUBE ASSEMBLY SCALE 1:15 REV. F SHEET 1 OF 2 COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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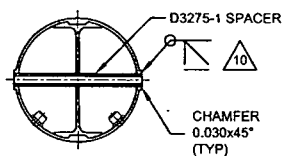
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07.12.19.14



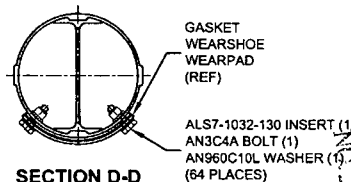
**DETAIL A: DRILL DETAIL**



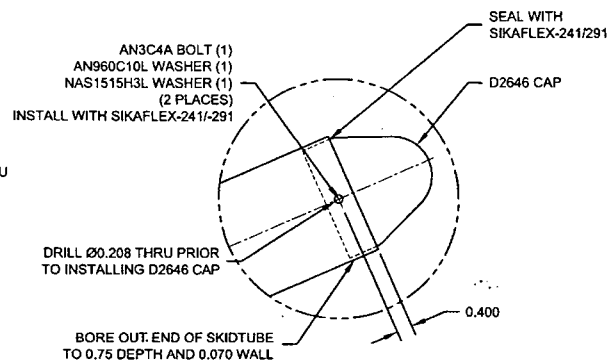
**SECTION B-B**  
FOR Ø0.375 HOLES ONLY  
(TYP, 9 PLACES)



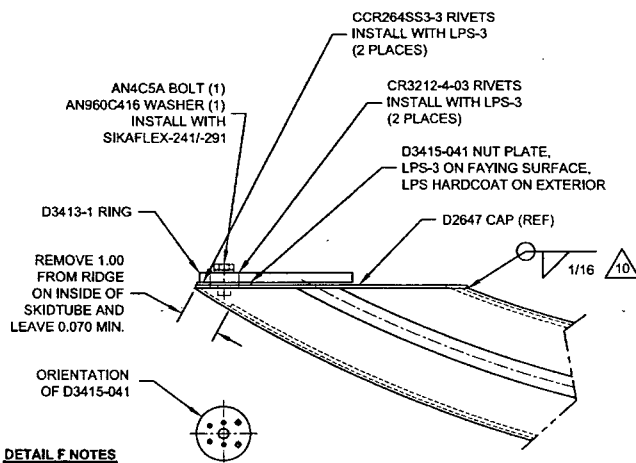
**SECTION C-C**  
FOR Ø0.313 HOLES ONLY  
(TYP, 6 PLACES)



**SECTION D-D**  
FOR WEARSHOES INSTALL ONLY  
(TYP, 32 PLACES)



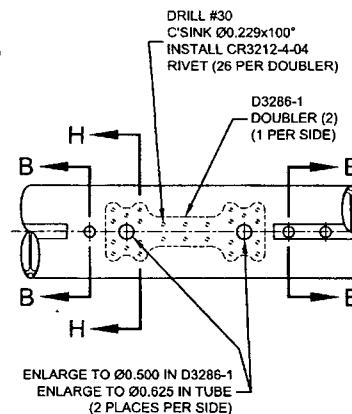
**DETAIL E**



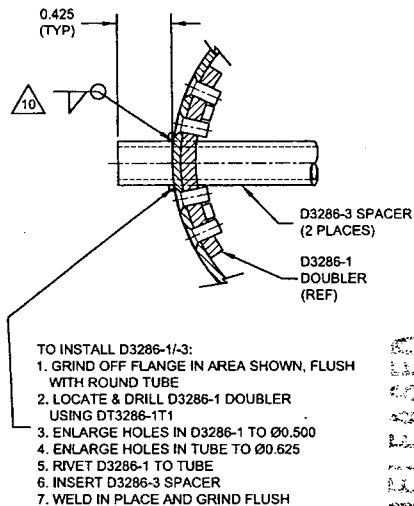
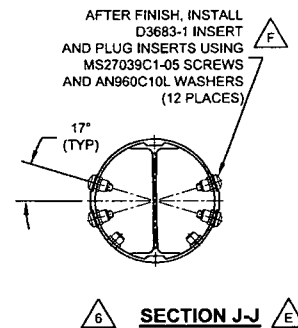
**DETAIL F NOTES**

1. CUT TUBE LEVEL
  2. REMOVE RIDGE ON FWD SIDE
  3. LOCATE D2647 (TRIM AS NECESSARY)
  4. WELD D2647 IN PLACE PER DART QSI 004
  5. GRIND FLUSH
  6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

**DETAIL F: END FINISHING DETAIL**



**DETAIL G**  
SCALE 1:5



**SECTION H-H**  
NOT TO SCALE

DESIGN	DP	<b>DART AEROSPACE LTD</b>	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. F
MFG. APPR.	AS	D3288	SHEET 2 OF 2
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	SKIDTUBE ASSEMBLY	1:3
DATE	07.11.21	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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NO. 146

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliot  
Job number: 37704A  
Part number: D058 612 041  
Description: OH-SB skid tube  
Welding Process: Tig ☒ Mig ☐  
Base material: Aluminium  
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐  
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐  
Undercut: pass ☒ fail ☐  
Pin holes: pass ☒ fail ☐  
Overlap (cold lap): pass ☒ fail ☐  
Porosity (surface): pass ☒ fail ☐  
Coloration: pass ☒ fail ☐

Qualifier Pct. Dupcl. Date of Test Coupon 08-03-28

Welder Barclay Elliot Date of Test Coupon 08-03-28

The above named individual is qualified in accordance with AWS D17.1.2001 to weld